

Date: Friday, 23/05/2008 12:41:36 PM  
 User: Julie Lecocq

## Process Sheet

SPRINT 460  
 08/06/22

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 39455  
 Estimate Number : 10495  
 P.O. Number :  
 This Issue : 23/05/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 36750  
 Written By :  
 Checked & Approved By : JUL 08.5.23  
 Comment : est rev H 07.06.12 ecn 825 EC

Drawing Name : LITTER TIE DOWN ASSY (LOCKING) - UNDER REVIEW  
 Part Number : D2360  
 Drawing Number : D2360REVD,D2341REVF  
 Project Number : N/A  
 Drawing Revision : D / F  
 Material :  
 Due Date : 15/06/2008 Qty: 5 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6201 "T" Extrusion



Comment: Qty.: 1.1067 f(s)/Unit Total : 6.6402 f(s)  
 Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)  
 Batch: B36793 mf 08/06/21 (6)

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks: 12.65" Long mf 08/06/21 (6)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio D2341 and Dwg D2341 mf 08/06/22 (6) Ro

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE mf 08/06/27 (6)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK JUL 08.06.23 (6)

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Deburr and Tumble JUL 08.06.23



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2360 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: A Date: 08/07/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>39455</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.23	3	3.313 Dim 'S' 3.293. ENTIRE PROFILE SHIFTED DOWN BY 0.020"	CP 08.06.23 PVR 05/04/2	PART ACCEPTABLE. THICKNESS OF ATTACHMENT POINTS UNAFFECTED.	gml 08/06/23	5 05/06/23	CP 08.06.23 PVR 05/04/2	5 05/06/23

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 39455

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*ala 08/06/23*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*m-l*

*08/06/24*

*(6X)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M 107925*

START TIME:

*11:45*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*12:15*

*BR 08-06-26*

*(6)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*EB 08/06/26 (5)*

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Knob

*B 161773*

*EB 08/06/26*

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lock Channel

*B 36577 (5X)*

*B 39474 (1X)*

*EB 08/06/26*

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Inventory

*B 37431*

*EB 08/06/26*

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Inventory

*B 33794*

*EB 08/06/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 39455

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)  
Quick Release *B39456*

*EB08/06/26*

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Spring *B36922*

*EB08/06/26*

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Pip Pin Assembly *B38895*

*EB08/06/26*

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Screw *M10600 M3041 M4523*

*EB08/06/26*

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)  
Washer *M108077*

*EB08/06/26*

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)  
Washer *M104885*

*EB08/06/26*

21.0

MS20470AD34

Rivet,Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Rivet,Universal Head *M15541*

*EB08/06/26*

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)  
Nut *M107665*

*EB08/06/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 39455

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Screw M105211

EB08/06/26

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)  
Screw M106923

EB08/06/26

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Nut M1463

EB08/06/26

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per dwg D2360

EB08/06/26

(5)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

000627(5)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 185

8/6/27

(5)

SP

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/01

Job Completion



mf 08-06-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 39455
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	+/-0.010	1.501	✓			
1.000	+/-0.010	1.060	✓			
Ø0.242	+0.005/-0.001	Ø.243	✓			
Ø0.191	+0.005/-0.001	Ø.193	✓			
R0.250	+/-0.010	R.250	✓			
→ 1.700	+/-0.010					
0.750	+/-0.010	.753	✓			
2.750	+/-0.010	2.755	✓			
11.000	+/-0.005	10.997	✓			
5.500	+/-0.010	5.496	✓			
1.584	+/-0.010	1.589	✓			
Ø0.191	+0.005/-0.001	Ø.193	✓			
2.610	+/-0.010	2.615	✓			
0.844	+/-0.010	.844	✓			
1.250	+/-0.010	1.254	✓			
0.750	+/-0.010	.754	✓			
12.500	+/-0.010	12.502	✓			
3.313	+/-0.010	3.316	✓			
4.250	+/-0.010	4.249	✓			
0.400	+/-0.010	.400	✓			

Measured by: <i>mk</i>	Audited by: <i>DP</i>	Prototype Approval:	N/A
Date: 08/04/22	Date: 08/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM <i>JA</i>	<i>BE</i>





**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

**RELEASED**

07 06 07

**PARTS LIST:**

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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WORK ORDER  
NO. 39455

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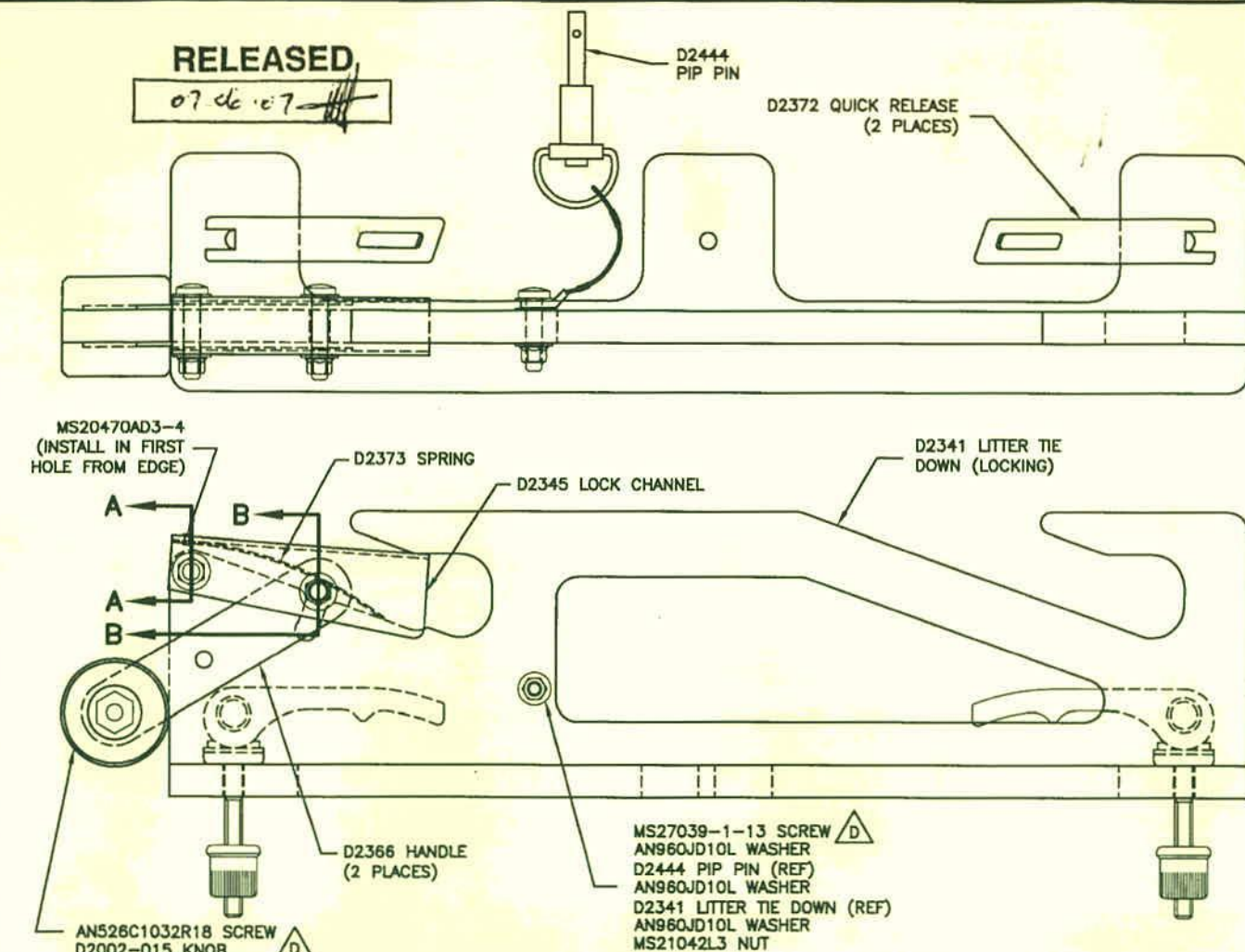
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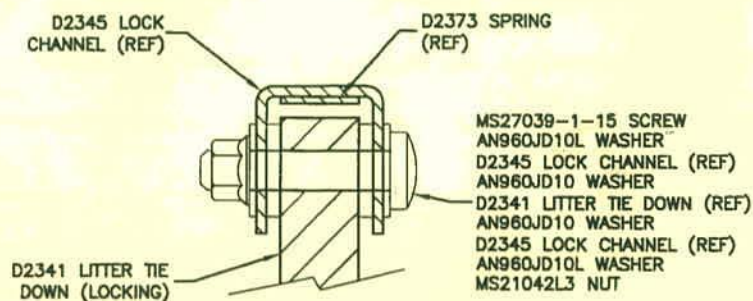


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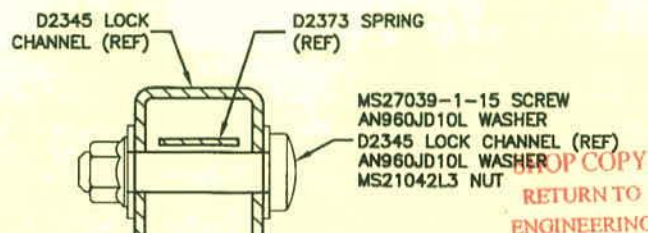
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CHECKED <b>CE</b>	APPROVED <b>H</b>	DRAWING NO. D2360	SHEET 2 OF 2
DATE 07.06.06	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE	



### D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



**SECTION A-A**  
(SCALE 1:1)



**SECTION B-B**  
(SCALE 1:1)

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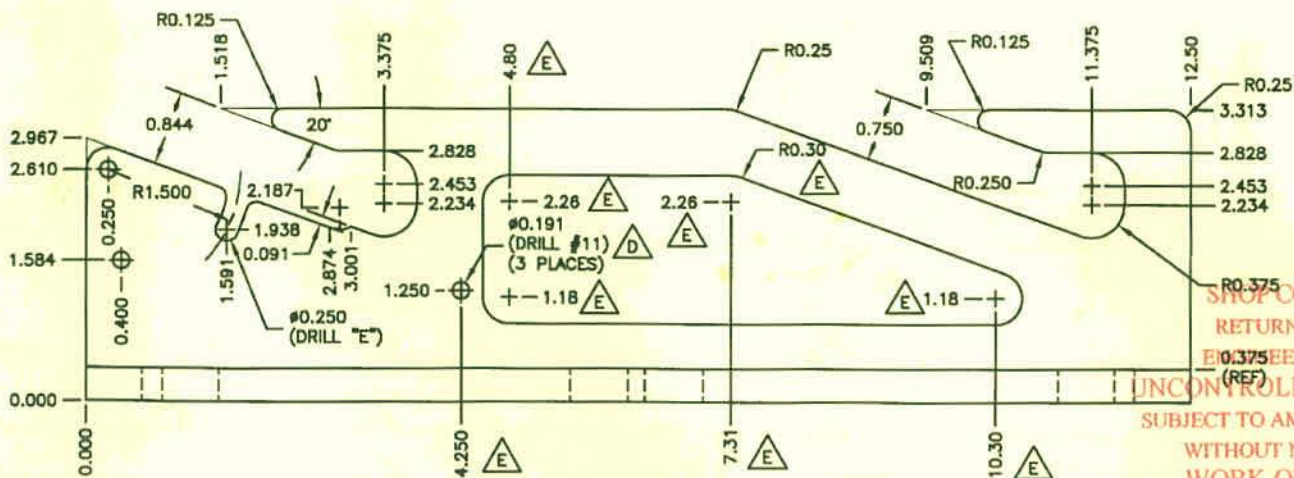
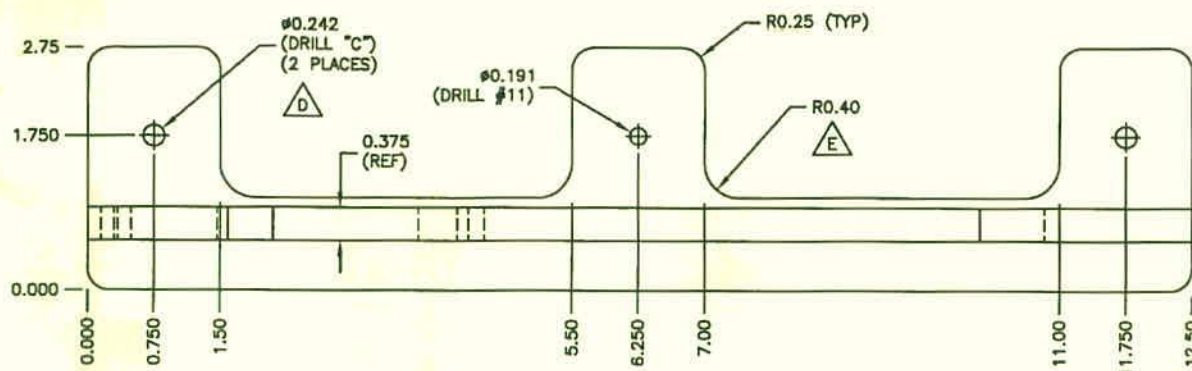
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**DART**

DESIGN BW	DRAWN BY SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION (6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

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07.06.22

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